

Work Order ID 128401

128401

Page 1

Friday, January 16, 2015 2:36:15 PM

Item ID: D2348 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate (Key Way)
 Start Date: 1/16/15 Start Qty: 30.00 *30* Cust Item ID:
 Required Date: 1/16/15 Req'd Qty: 30.00 *30* Customer:
 Reference:

Approvals: Process Plan: MLS Date: 15-01-19 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2348	Rev C								

100		0.00							
100	FLOW WATER JET					30	0		Jm 15-2-1
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D2348								
600e1.003	Dwg Rev: <u>C</u>								
	Prog Rev: <u>C</u>								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110						30	0		Jm 15-2-1
QC	Memo	0.00							
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							
Quality Control									

68-6
8C
SND
FEB 2 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Crosstube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design ☐									
Doc/Data ☐									
Equip/Tooling ☐									
Handling/Pre ☐									
Material ☐									
Operator ☐									
Offset/Setup ☐									
Process ☐									
Supplier ☐									
Training ☐									
Transport ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Outsource process-Anodize per QSI017 4.1.10.1	0.00							
150									
Outsource4	Memo	0.00							MLJ 15-02-04 30
Outsource process - Anodize	Issue P/O: 27338 Black Anodize per Dwg D2348 Ensure Certificate of Conformity is attached								
160	Receive & Inspect for Damage & Mat'l Certs	0.00							
160									
Packaging	Memo	0.00							30x 8015-02-18
Packaging	Ensure certificate of conformity is attached								
170	QC5- Inspect part completeness to step on W/O	0.00							
170									
QC	Memo	0.00							30 DAS 38 9-89
Quality Control	INSPECT CERTS								

FEB 18 2015

DQA: _____ Date: _____



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Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Item Name: Wearplate (Key Way)
Start Date: 1/16/15 Start Qty: 30.00 ***30*** Cust Item ID:
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21 - Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

15/2/2348
MS2-23

DQA: _____ Date: _____



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Picklist Print

Friday, January 16, 2015 2:36:14 PM

Page 1

Work Order ID: 128401

128401

Parent Item: D2348

D2348

Parent Item Name: Wearplate (Key Way)

Start Date: 1/16/15

Required Date: 1/16/15

Start Qty: 30.00

Required Qty: 30.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3996-FE-832-EF		Manufactured	No			180	Each	115.0000	4	120			DAS

D3996-FE-832-EF

Self-Clinching Fastener

15/02/19
B128979
(52)

Location

Loc Qty

Loc Code

GA

115

119829

115

M6061T6S.063

Purchased

No

100

sf

116.9148

0.0198

0.625263

M6061T6S 063

6061-T6 .063 Sheet

(1)

Jm 15-2-1

Location

Loc Qty

Loc Code

MAT021

116.9148

M128941

18.5

M129845

30.8353

M130096

25

M130745

42.5795

130745

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Training									
Transport									
Unapproved									

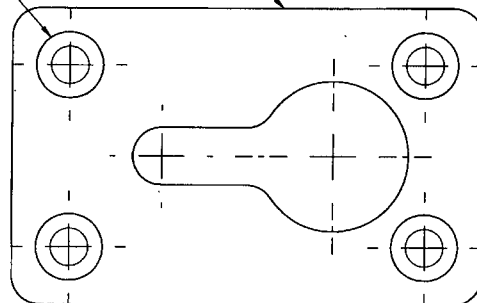
FAULT CATEGORY

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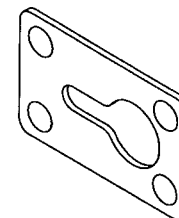
ITEM	QTY	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLAT PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER

D3996-FE-832-EF
SELF-CLINCHING FASTENER
4 PL

D2348F



D2348 WEAR PLATE



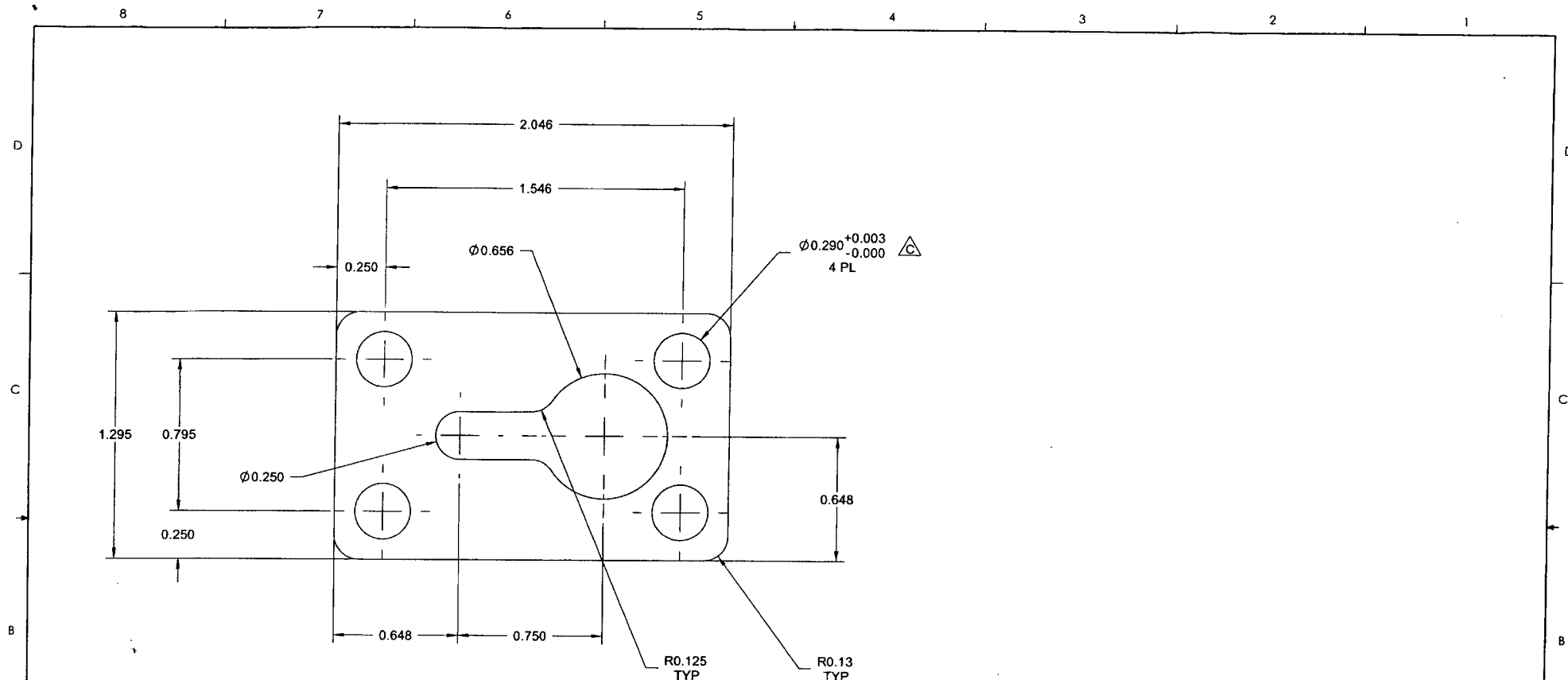
SHOW
RETURN
ENGINEER
UNCONTROLLED
SUBJECT TO
WITH
WORK

NO. 128401 MJS
150119

RELEASED
2009-11-09

- NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
7) WEIGHT: 0.01 lbs

C	REDRAW, ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T6	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO 8-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	97		
CHECKED	18	DRAWING NO.	REV. C
MFG. APPR.	18	D2348	SHEET 1 OF 2
APPROVED	18	TITLE	SCALE
DE APPR.	18	WEAR PLATE	NTS
DATE	09.10.01	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D2348F FLAT PATTERN

RELEASE
2009-11-08

NOTES:

- NOTES:**
- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/B/C1/I/B CLASS 2
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348F" USING REMOVABLE TAG
 - 7) WEIGHT: 0.01 lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	<i>GP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>LB</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D2348	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEAR PLATE	NTS
DATE	09.10.01	COPYRIGHT © 1999 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO27338**

Purchase Order Date 2/4/2015

PO Print Date 2/10/2015

Page Number 1 of 4

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	128401	D2348 WEARPLATE REV. C	2/17/2015		30.00 ✓	\$0.95	\$28.50
			Yes 2/17/2015				
	FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB / IC / II / IIB CLASS 2, TYPE III CLASS 2						
					SP15-0218		
					Line Total:		
							\$28.50
2	128438	D4703-043 LOCK PIN REV. A	2/17/2015		8.00	\$0.90	\$7.20
			Yes 2/17/2015				
	FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR IB / IC / II / IIB CLASS 2, TYPE III CLASS 2						
					Line Total:		
							\$7.20

Note:

2/10/2015



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada

Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63531

Date: 13-Feb-15

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
30 ea	Part: D2348 WEARPLATE ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 Job: 20150113 PO: PO27338	Rev: C	Line: 5015-02-18
8 ea	Part: D4703-043 LOCK PIN ANODIZE AS PER MIL-A-8625 TY II, CLASS 2 Job: 20150114 PO: PO27338	Rev: A	Line:
4 ea	Part: D5211-1 BLUE ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20150115 PO: PO27338	Rev:	Line:
14 ea	Part: 646.3812 GUSSET BRACKET HARD ANODIZE AS PER MIL-A-8625 TY III, CLASS 2 PRIME AS PER MIL-P-23377J TYPE I CLASS N PRIMER IS SUPPLY BY THE CUSTOMER Job: 20150116 PO: PO27338	Rev:	Line:
4 ea	Part: 647.0410 TUBE REV HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLIED BY CUSTOMER Job: 20150117 PO: PO27338	Rev:	Line:
6 ea	Part: 647.9710 HARD ANODIZE BLACK	Rev:	



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Pack List

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HAWKESBURY, ON K6A 1K7
Canada

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Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms		Ship Via	
Quantity	Description		
	MIL-A-8625 TYPE III CLASS 2 PRIME MIL-P-23377J TYPE I CLASS N PAINT IS SUPPLY BY CUSTOMER Job: 20150118 PO: PO27338 Line:		
Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE : <u>13/2/15</u> CERTIFIED SIGNATURE : <u>[Signature]</u> RECEIVER SIGNATURE : _____ Sp15-02-18			